

Tuesday, January 17, 2017 11:22:21 AM

Page 1

NR2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

Tuesday, January 17, 2017 11:22:21 AM

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[illegible]

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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Root Cause				FAULT CATEGORY			
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Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐				
				OTHER :			

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Page 3

NS1

NS2

Customer:

NR1

NR2

**Insp.
Stamp**

4

17-3-1

0.01

५

DAS
38
000

13 2017

0.08

FX

1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

17/03/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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NS1

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
12-1-0 30 12-1-0				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
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OTHER : _____							

Work Order ID 155510

Tuesday, January 17, 2017 11:22:21 AM

155510

Page 5

Item ID: D3294-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket For Interior Window For -115

Start Date: 1/10/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/17/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: 51435

0.00

21051439

Packaging

Memo

0.01

8

DAS

41

9-89

MAR 27 2017

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.13

17/3/28 98

Quality Control

DAS
21
9-89

MAR 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐																									

Picklist Print

Tuesday, January 17, 2017 11:22:20 AM

Page 1

Work Order ID: 155510

155510

Parent Item: D3294-1

D3294-1

Parent Item Name: Bracket For Interior Window For -115

Start Date: 1/10/2017

Required Date: 1/17/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A04.08.24New issueKJ/JLM
IPP Rev:B Now On Waterjet 07-03-26 JLM
IPP Rev:C 08-07-16 Redesign part DD verified by:EC
IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	71.6000	1.8	15.15789			
M2024T3S 080									**				
2024-T3 .080 sheet													

Location

Loc Qty

Loc Code

MAT021

71.6

M127668

4

M129584

8.4

M129891

4.9

M135288

6.3

M136342

48

D3294-5

Manufactured

No

D3294-5

Doubler

170

Each

5.0000

1

8

23.8

Location

Loc Qty

Loc Code

GA

5

129537

1

150320

4

MS20470AD4-5

Purchased

No

MS20470AD4-5

RIVET, UNIVERSAL HEAD

170

Each

883.0000

15

120

Location

Loc Qty

Loc Code

GA

37

m133860

37

ST310

846

m134654

846

DAS
46
9-89
17/03/15

17/03/15
DAS
36
9-89

B153505 (4x)
B156817 (4x)

17/03/15
DAS
36
9-89

~~120~~ 79

M136851
(41x)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐	☐	Past Due ☐																							

DART AEROSPACE LTD		Work Order: 155510
Description: Bracket Assembly		Part Number: D3294-1
Inspection Dwg: D3294	Rev: D	Page 1 of 1

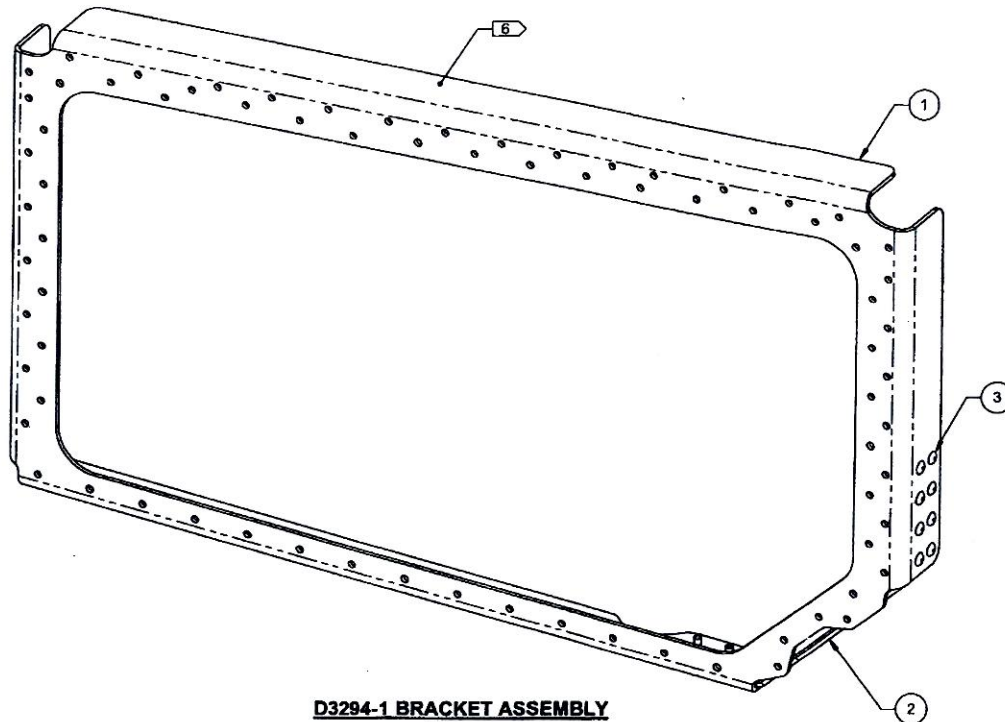
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	✓		Dc.01	
Ø0.141	+0.005/-0.001	0.142	✓		Tape	
6.708	+/-0.010	6.712	✓			
1.118	+/-0.010	1.119	✓			
5.590	+/-0.010	5.595	✓			
1.118	+/-0.010	1.119	✓			
13.563	+/-0.010	13.563	✓			
1.043	+/-0.010	1.044	✓			
0.625	+/-0.010	0.626	✓			
0.325	+/-0.010	0.329	✓			
0.300	+/-0.010	0.306	✓			
0.400	+/-0.010	0.402	✓			
6.000	+/-0.010	6.002	✓			
1.000	+/-0.010	1.001	✓			
17.124	+/-0.010	17.124	✓			
16.13	+/-0.030	16.13	✓			
7.27	+/-0.030	7.277	✓			
11.97	+/-0.030	11.97	✓			
8.37	+/-0.030	8.382	✓			
20.05	+/-0.030	20.05	✓			
12.98	+/-0.030	12.98	✓			
14.59	+/-0.030	14.59	✓			
11.66	+/-0.030	11.66	✓			
0.080	+/-0.010	0.080	✓			

Measured by: DAS 46 9-89	Audited by: DAS 38 9-89	Preliminary Approval:
Date: 17/03/04	Date: MAR 06 2017	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	

ITEM	QTY	P/N	DESCRIPTION
	X	D3294-1	BRACKET ASSEMBLY
1	1	D3294-3	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



D3294-1 BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155510 MJS
17.01-18

RELEASED
2012-11-21

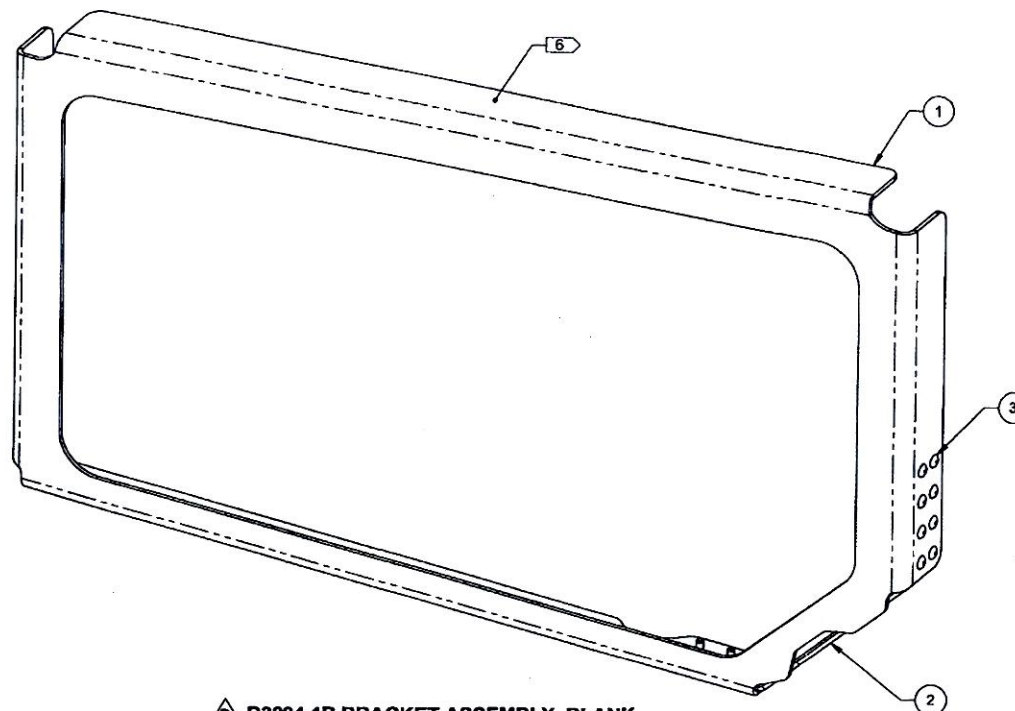
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.008 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.83 lbs

D	ADD D3294-1B/-3B/-3FB. REASON: PAR12-223.	MB	12.11.15
C	REMOVE FLANGE PREVIOUSLY ADDED ADD -5 DOUBLER ZN A4-1, SHEET 5+6	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	12.11.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3294	REV. D
TITLE BRACKET	SHEET 1 OF 9
	SCALE NTS
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ITEM	QTY -1B	P/N	DESCRIPTION
	X	D3294-1B	BRACKET ASSEMBLY, BLANK
1	1	D3294-3B	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



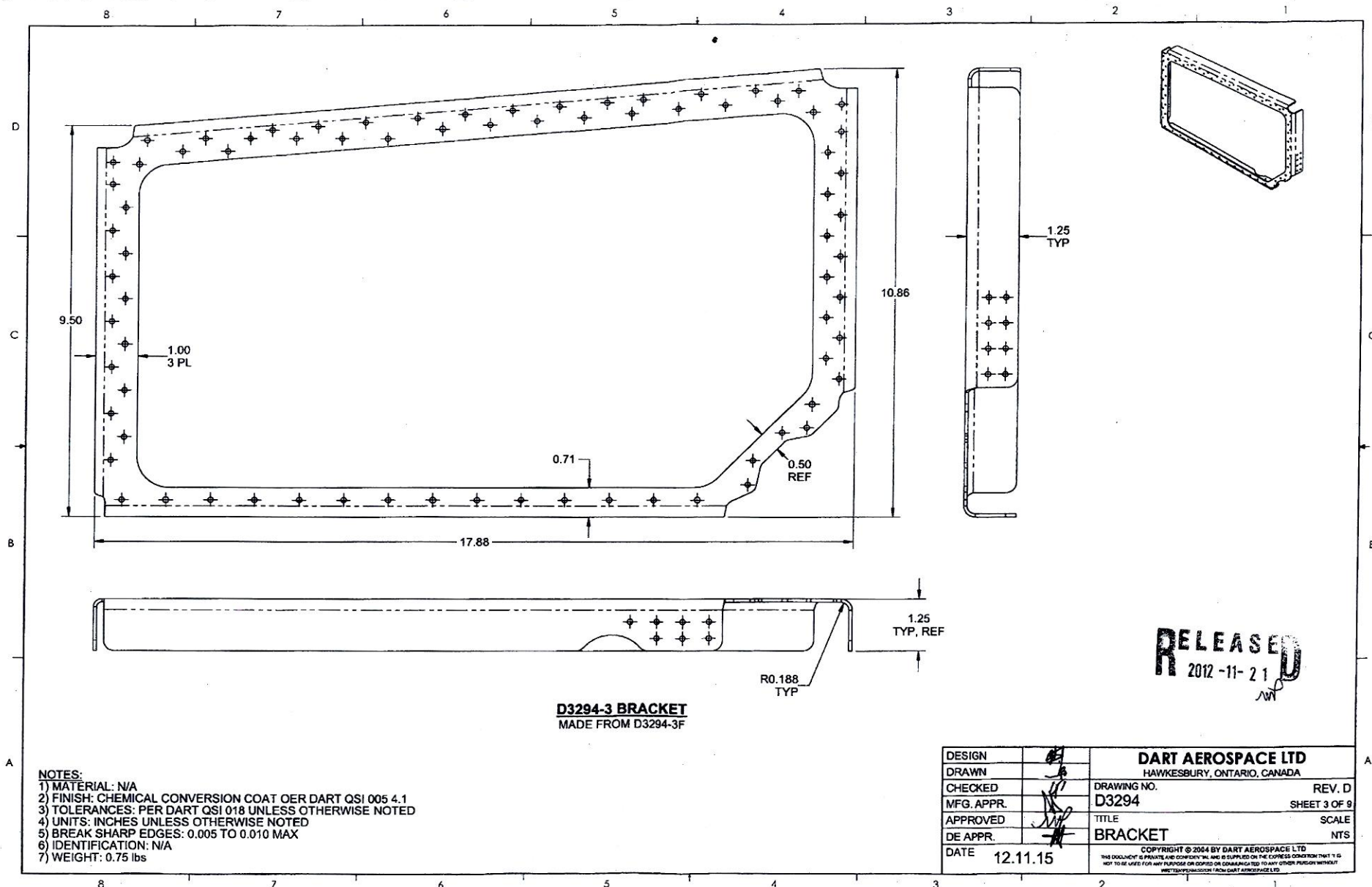
D3294-1B BRACKET ASSEMBLY, BLANK

RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1B" PER DART QSI 044 8.1
- 7) WEIGHT: 0.83 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3294	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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RELEASED
2012-11-21

